

Slp 14/06

16

Work Order ID 70660

Monday, June 13, 2011 6:56:13 AM



Page 1

Item ID: D3575-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Floor Protector

Start Date: 6/13/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: [Signature] Date: _____ Tooling: _____ Date: _____

Run Start



QC: [Signature] Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3575	Rev A

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3575 ☒ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

11-6-13

(2)

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11-6-13

120 0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sublocky

(77)

Work Order ID 70660

Monday, June 13, 2011 6:56:13 AM



Page 2

Item ID: D3575-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Floor Protector

Start Date: 6/13/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
	Memo	0.00	SB 11/6/14						
	Debur if necessary.								
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00	8 w/o 6/14						
	Quality Control								
150 Packaging	Identify as per dwg & Stock Location: _____	0.00							
	Memo	0.00	11/6/14 SL(2)						
	Packaging								

Work Order ID 70660

Monday, June 13, 2011 6:56:13 AM

Page 3

Item ID: D3575-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Cabin Floor Protector

Start Date: 6/13/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 6/14/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/14
mf
11-06-14

Picklist Print

Monday, June 13, 2011 6:56:10 AM

Page 1

Work Order ID: 70660



Parent Item: D3575-1



Parent Item Name: Cabin Floor Protector

Start Date: 6/13/2011

Required Date: 6/14/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev :A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.125-F60029-04

Purchased

No

100

sf

1,758.215

10.666

22.45474



GE PLASTICS LEXAN SHEET

B11-6-13

Location

Loc Qty

Loc Code

MAT018

1758.215789

116236

1758.21579

116236

DART AEROSPACE LTD		Work Order: <i>Folded</i>
Description: Cabin Floor Protector		Part Number: D3575-1
Inspection Dwg: D3575	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.003	✓		VHB02	
1.00	+/-0.030	1.00	✓		T HB01	
3.50	+/-0.030	3.50	✓		T	
16.00	+/-0.030	16.00	✓		T	
23.13	+/-0.030	23.13	✓		T	
26.88	+/-0.030	26.88	✓		T	
27.69	+/-0.030	27.69	✓		T	
4.25	+/-0.030	4.25	✓		T	
9.63	+/-0.030	9.63	✓		T	
16.13	+/-0.030	16.13	✓		T	
28.06	+/-0.030	28.06	✓		T	
32.15	+/-0.030	32.15	✓		T	
2.00	+/-0.030	2.00	✓		T	
3.50	+/-0.030	3.50	✓		T	
14.25	+/-0.030	14.25	✓		T	
25.13	+/-0.030	25.13	✓		T	
29.38	+/-0.030	29.38	✓		T	
30.13	+/-0.030	30.13	✓		T	
1.25	+/-0.030	1.25	✓		T	
3.38	+/-0.030	3.38	✓		T	
5.00	+/-0.030	5.00	✓		T	
6.50	+/-0.030	6.50	✓		T	
26.13	+/-0.030	26.13	✓		T	
31.50	+/-0.030	31.50	✓		T	

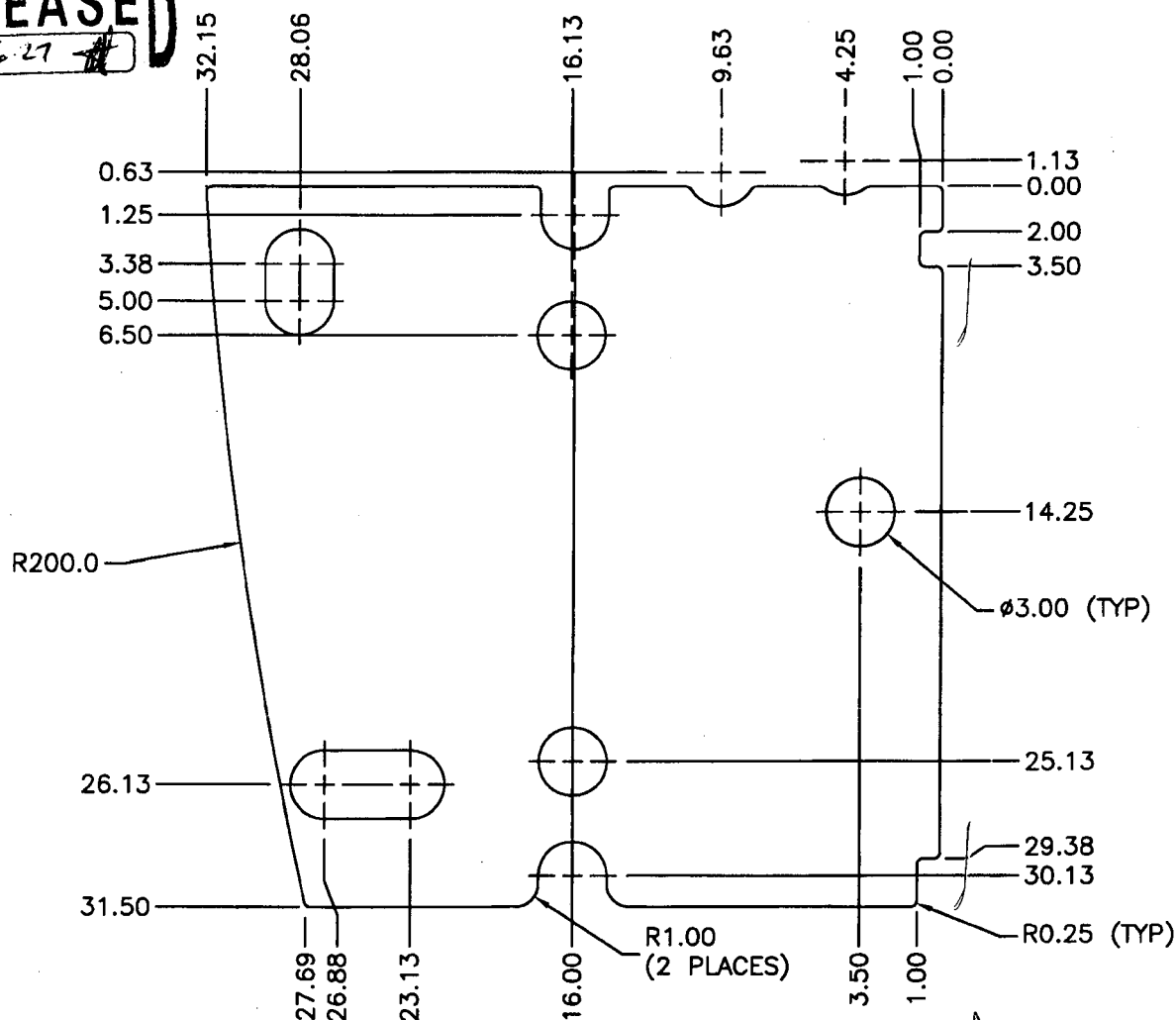
Measured by: <i>RB</i>	Audited by: <i>8</i>	Prototype Approval:	N/A
Date: 11-6-13	Date: 11/06/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.29	New Issue	KJ/DD <i>8</i>	<i>RB</i>



DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>#</i>	DRAWING NO. D3575	REV. A SHEET 1 OF 4
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:8
A	07.06.08	NEW ISSUE	

RELEASED
07.06.27



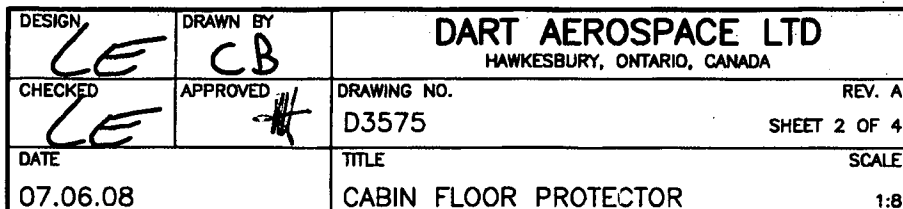
D3575-1 CABIN FLOOR PROTECTOR (SHOWN)
D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

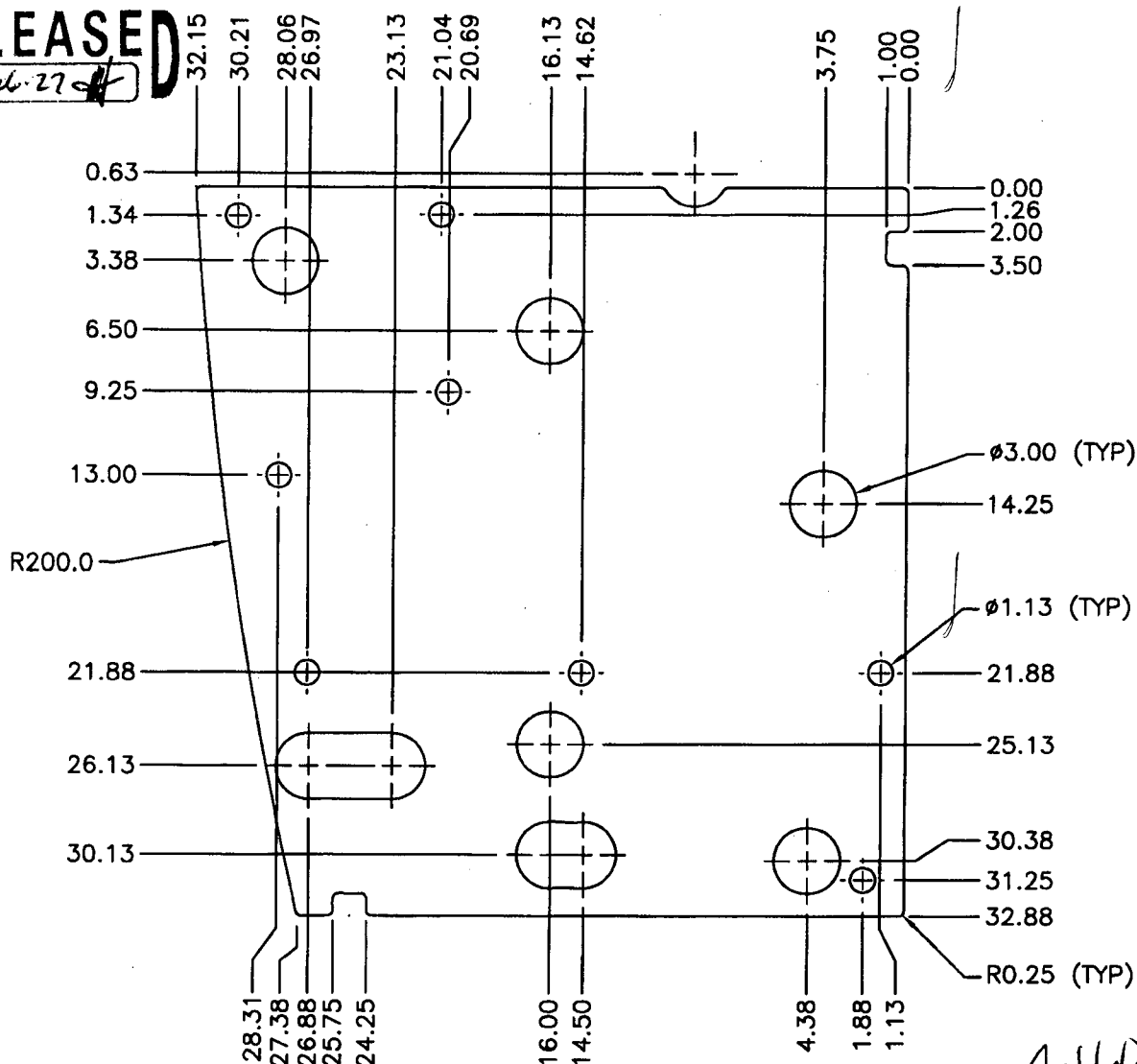
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8966

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07-06-27



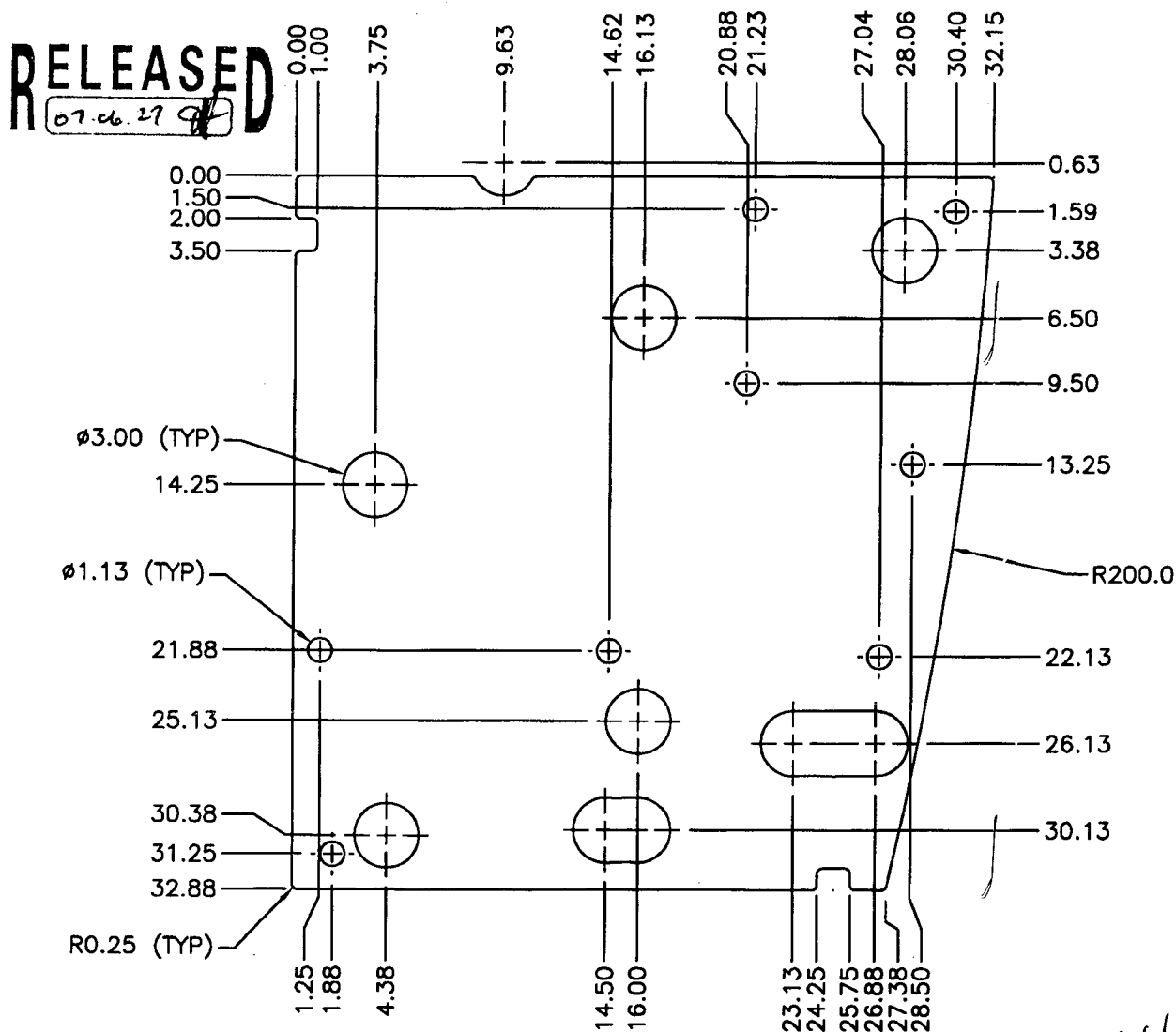
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- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK,
TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-3" USING FINE POINT PERMANENT INK MARKER
ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8967

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DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>AK</i>	DRAWING NO. D3575	REV. A SHEET 3 OF 4
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:8



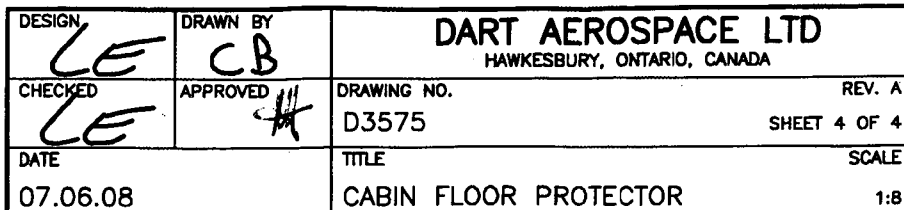
D3575-4 CABIN FLOOR PROTECTOR

NOTES:

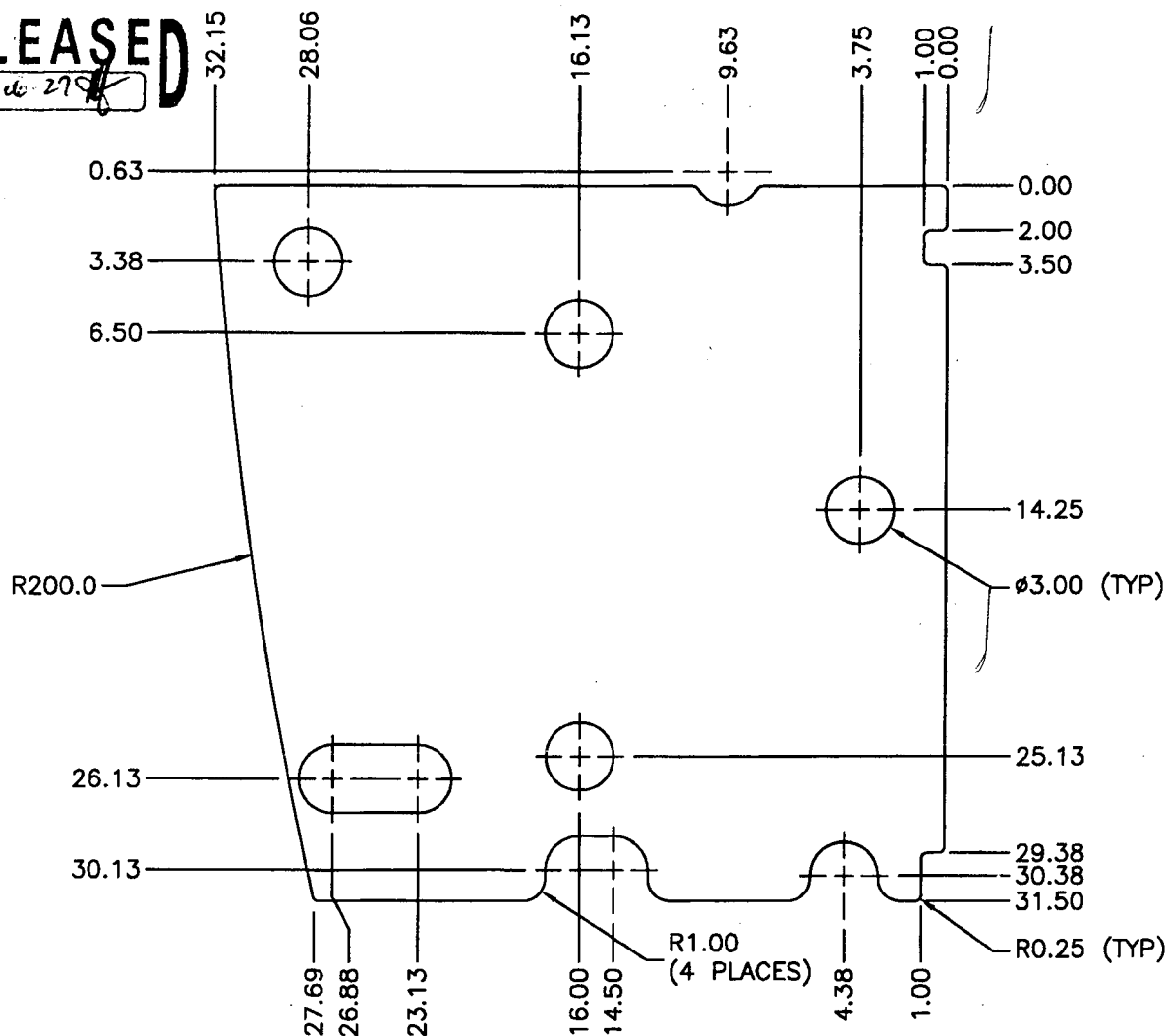
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8968

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07-06-279



Added

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK,
TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER
ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8969

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